



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2364

Job Sheet 211689



Part No: D2364

Job Qty: 8 pcs

Part Name: Deck Plate Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/24/20

Job Tracking No:

Due Date: 8/24/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV G IPP REV. E00.06.26 Removed P/O for powder coat EC IPP Rev:F Now On Waterjet 06-07-03
JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		8/22/20	0.17	1.00	Waterjet - Flow		on 20/07/31
110	QC 2	8 pcs		8/22/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		on 20/07/31
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120	QC 8	8 pcs	8/22/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
130	Small Fab - 2 - B4B	8 pcs	8/22/20	0.00 0.79	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
					Small Fab - 8 - B4B
					Small Fab - 9 - B4B
					Small Fab - Various 1 - B4B
140	QC 5	8 pcs	8/22/20	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49

DAS
AUG 04 2020 40
9-89

DAS
58 AUG 06 2020
9-89

						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	DAS
						QC 5 - 61	82
						QC 5 - 81	9-89
						QC 5 - 82	0707 / 0 90V
150 Handfinish - 1-1 Chemical-B4B	8 pcs	8/22/20	0.00 0.39			Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
160 Powdercoat - 4 Black Sand - B4B	8 pcs	8/24/20	0.00 0.15			Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
						Powdercoat - 5 - B4B	
						Powdercoat - 6 - B4B	
						Powdercoat - 7 - B4B	
						Powdercoat - 8 - B4B	
						Powdercoat - 9 - B4B	
						Powdercoat - 10 - B4B	
170 QC 3	8 pcs	8/24/20	0.00 0.00			QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	

					QC 3 - 40	AUG 13 2020	DAS 40
					QC 3 - 19		9-89
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
					QC 3 - 82		
					QC 3 - 87		
					Packaging 3 - 1 - B4B		
					Packaging 3 - 2 - B4B		
180 Packaging 3-1 - Stock - B4B	8 pcs	8/24/20	0.00 0.00		Packaging 3 - 3 - B4B		DAS 28
					Packaging 3 - 4 - B4B		9-89
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B	AUG 14 2020	
					Packaging 3 - 9 - B4B		
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		
					Packaging 3 - 16 - B4B		
					Packaging 3 - 17 - B4B		
					Packaging 3 - 18 - B4B		
					Packaging 3 - 19 - B4B		
					Packaging 3 - 20 - B4B		
					Packaging 3 - 21 - B4B		
					Packaging 3 - 22 - B4B		
					Packaging 3 - 23 - B4B		
					Packaging 3 - 24 - B4B		
					Packaging 3 - 25 - B4B		
					Packaging 3 - 26 - B4B		
					Packaging 3 - 27 - B4B		
					Packaging 3 - 28 - B4B		
					Packaging 3 - 29 - B4B		
					Packaging 3 - 30 - B4B		
					Packaging 3 - 31 - B4B		
					Packaging 3 - 32 - B4B		
					Packaging 3 - 33 - B4B		
					Packaging 3 - 34 - B4B		
					Packaging 3 - 35 - B4B		
					Packaging 3 - 36 - B4B		DAS 21
					Packaging 3 - 37 - B4B		9-89
190 QC 21 - SA	8 pcs	8/24/20	0.00 0.00		QC 21 - SA - 21		
					QC 21 - SA - 70		
					QC 21 - SA - 9		AUG 14 2020
					QC 21 - SA - 77		

Part Op 100 - 1-Cut as per Dwg D2364

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Small Fab) 1- Counter sink holes as per dwg D2364

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location:_____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	5.1752 sf (.6469 ea)	100-Waterjet - Flow - 1	5252605
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	5	154	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order: 211689
Description: Litter Deck Plate Kit (350)		Part Number: D2364
Inspection Dwg: D2364	Rev: G	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.625	1		✓: 0.04	
Ø0.171	+0.005/-0.000	Ø.172	1		" "	
0.354	+/-0.010	.355	1		" "	
11.242	+/-0.010	11.243	1		" "	
3.031	+/-0.010	3.030	1		" "	
1.903	+/-0.010	1.904	1		" "	
1.128	+/-0.010	1.230	1		" "	
0.354	+/-0.010	.358	1		" "	
1.340	+/-0.005	1.339	1		" "	
2.326	+/-0.010	2.325	1		" "	
3.312	+/-0.010	3.314	1		" "	
4.298	+/-0.010	4.299	1		" "	
5.284	+/-0.010	5.283	1		" "	
6.151	+/-0.010	6.152	1		" "	
6.270	+/-0.010	6.272	1		" "	
0.354	+/-0.010	.353	1		" "	
3.031	+/-0.010	3.032	1		" "	
Ø0.656	+0.005/-0.000	Ø.656	1		" "	
5.003	+/-0.010	5.003	1		" "	
4.605	+/-0.010	4.605	1		" "	
1.776	+/-0.010	1.778	1		" "	
0.980	+/-0.010	.981	1		" "	
4.487	+/-0.010	4.490	1		" "	
7.192	+/-0.010	7.196	1		" "	
7.567	+/-0.010	7.570	1		" "	
7.942	+/-0.010	7.943	1		" "	
Ø0.191	+0.005/-0.000	Ø.193	1		" "	
Ø0.197	+0.005/-0.000	Ø.199	1		" "	
11.145	+/-0.010	11.146	1		" "	
12.181	+/-0.010	12.181	1		Tap	
11.776	+/-0.010	11.777	1		✓: 0.01	
0.250	+0.005/-0.000	.253	1		✓: 0.04	
3.141	+/-0.010	3.141	1		" "	
0.171	+0.005/-0.000	.172	1		" "	

Measured by: <i>an</i>	Checked by: 40	QC Inspector:
Date: 20/07/31	Date: AUG 04 2020	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	
C	16.05.30	Dimensions revised per Dwg Rev G	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S291403



Part: D2364

Job No: 211689

Serial No/Batch: S291403

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/31/20